

Work Order ID 61822

Tuesday, September 07, 2010 12:44:18 PM



Page 1

Item ID: D4104-041

Accept



Setup Start



Revision ID:

Item Name: Doubler Assembly

Stop



Start Date: 9/7/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 16-9-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D4104	A	

100



FLOW WATER JET

Waterjet

Memo

0.00

16-10-4-20

FLOW CNC Waterjet

6061 . 040

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr as required

110



QC2- Inspect parts off machine FAI/FAIB

0.00

16-10-4-20

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

S. Colombo
Counter
~20

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

E/S, 0/09/21 (20)

Small Fab

Memo

0.00

Small Fab

COUNTER SINK AS PER DWG

Deburr if necessary.

150



QC5- Inspect part completeness to step on W/O

0.00

S. Walker
09/09/2010

QC

Memo

0.00

Quality Control

160



Chemical Conversion Coat per QSI005 4.1

0.00

BL 10-9-23

HandFinish

Memo

0.00

Hand Finishing

(20) 09/09/2010

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

161



QC

Quality Control

QC3- Inspect Part Finish

0.00

M

10/09/22

X20 0

165



Small Fab

Memo

0.00

Small Fab

ASSEMBLE NUT PLATES AS PER DWG

166



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. Colosimo

Counted

X20

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location: 128

0.00

190



QC

Quality Control

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/8/2010 20

10/10/2010

*MWF
10-9-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, September 07, 2010 12:44:22 PM

Page 1

Work Order ID: 61822



Parent Item: D4104-041



Parent Item Name: Doubler Assembly

Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-09-06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	86.7300	0.03	0.189474		18 10-9-20	

6061-T6 .040 Sheet

Location	Loc Qty	Loc Code
MAT21	86.73	
	86.73	

1103447

MS21069-L3



Purchased

No

113004
W1

Each

0.0000

111227

12

E/S 10/09/28

Nut Plate

MS20426AD3-3



Purchased

No

Each

5,021.000

24

E/S 10/09/28

Rivet

Location	Loc Qty	Loc Code
ST316	5021	
19099	4774	
7681	247	

80

W/O:		WORK ORDER CHANGES							
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DART AEROSPACE LTD	Work Order:	61822
Description: DOWDIE2 ASSEmBLY	Part Number:	D4104-1
Inspection Dwg: D4104-1 Rev: A		Page 1 of 1

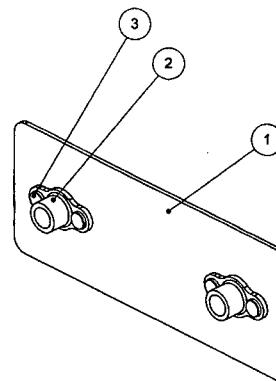
FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-20	Date:	10/09/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4104-041	DOUBLER ASSEMBLY
1	1	D4104-1	DOUBLER
2	2	MS21069-L3	NUT PLATE
3	4	MS20426AD3-3	RIVET



SHOP COPY
 RETURN TO
 ENGINEER
 UNCONTROLLED COPY
 SUBJECT TO ANNUAL REVIEW
 WITHOUT NOTICE
 WORK ORDER
 NO. 41822
B80-9-07

RELEASED
 2010-08-23
MP

D4104-041 DOUBLER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4104-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE		RF	10.05.06
REV.	DESCRIPTION		BY	DATE
DESIGN	RF		DART AEROSPACE LTD	
DRAWN	RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED	#		DRAWING NO.	REV. A
MFG. APPR.	#		D4104	SHEET 1 OF 2
APPROVED	#		TITLE	SCALE
DE APPR.	#		DOUBLER ASSEMBLY	NTS
DATE	10.05.06		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

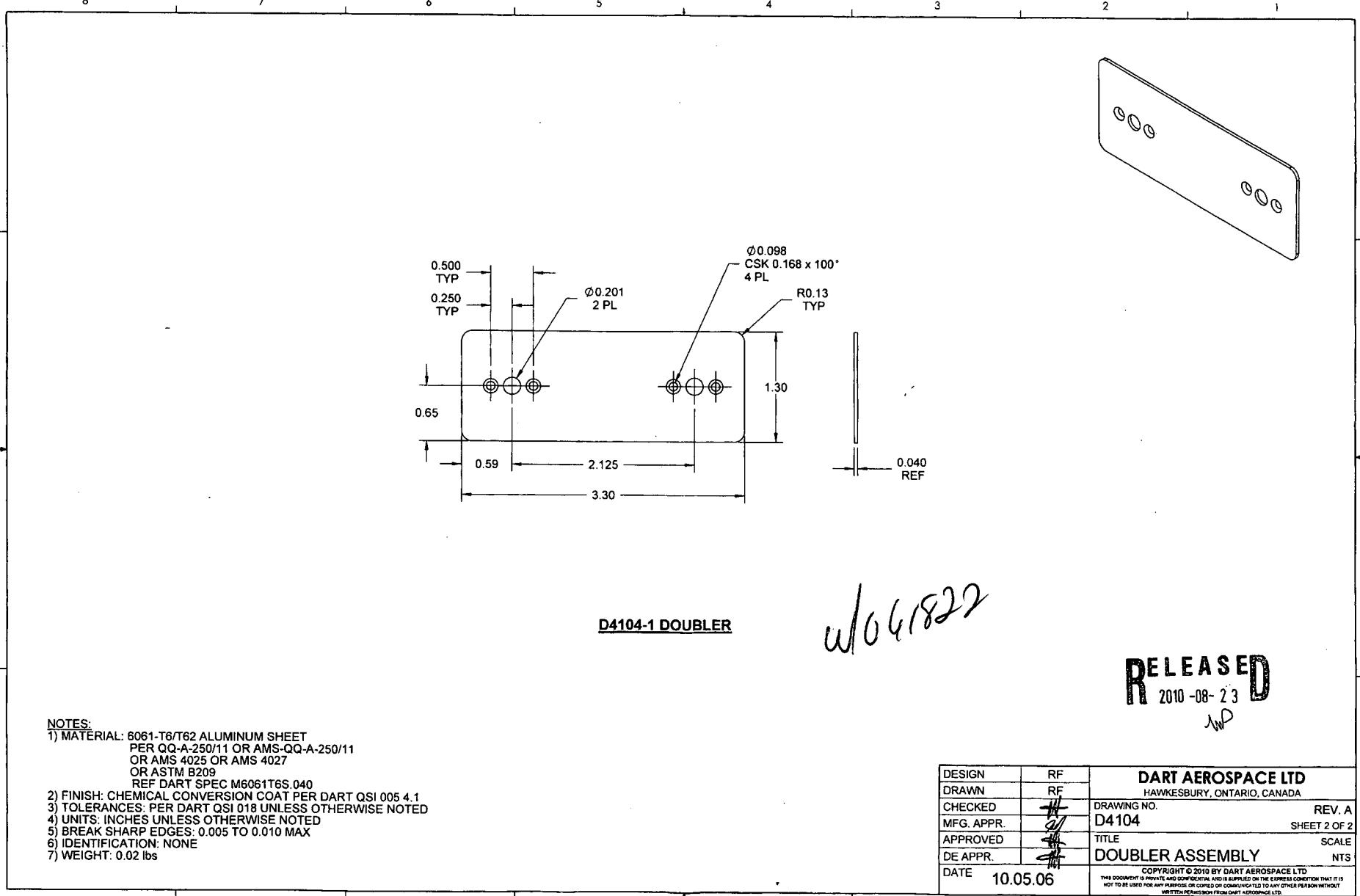
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